

Work Order ID 50175



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July 10, 2009 7:36:07 AM

Item ID: D3411-3

Accept



Setup Start



Revision ID: REVA

Prototype

Stop



Item Name: WASHER

Start Date: 07/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 07/10/2009 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn as per Folio FA591 Rev: _____ & Dwg D3411 Rev: _____
Deburr & Tumble as per Dwg D3411



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control



120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control



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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF
09-07-10
chg to 1200304306A

Picklist Print

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Work Order ID: 50175

Parent Item: D3411-3RevREVA

Parent Item Name: WASHER

Comments:

Start Date: 07/10/2009

Required Date: 07/10/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MDELNR1.000		Purchased	No			100	f	65.3100	0.2863			



Delrin Round Bar 1"



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

65.31

108757

39.98

108804

25.33

DART AEROSPACE LTD	Work Order:	0263
Description: Washer	Part Number:	D3411-3
Dwg: D3411 Rev. A	Qty:	20
		Page 1 of 1

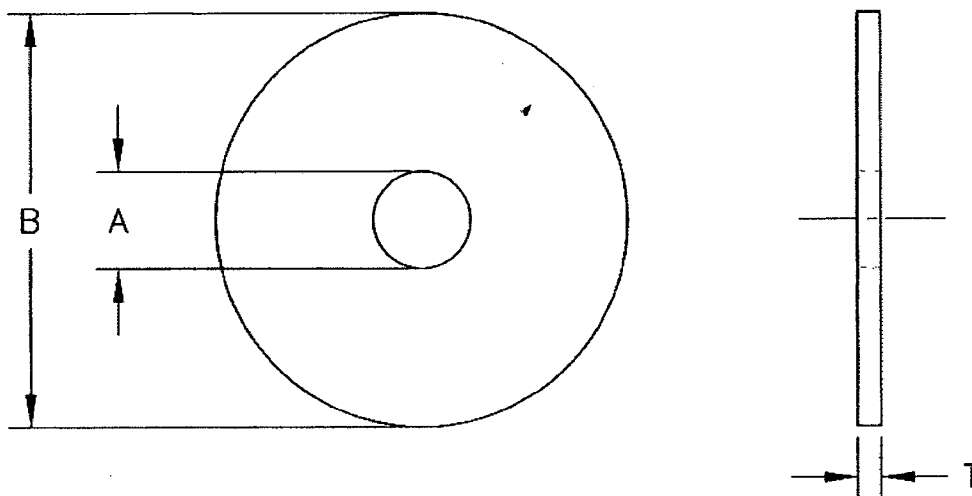
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
2	MC	Turn as per Folio FA591 Rev: <u>N/A</u> & Dwg D3411 Rev: <u>A</u> Material: Delrin Round Bar Ø1.000 (M-DELRIN-R1.000) Batch: <u>M108757</u> Identify for D3411-3	pmr	09/07/01	20
3	QC2	Inspect parts as they come off the machine Identify as D3411-3	pmr	09/07/01	20
4	QC8	Second check	JFS	09/07/01	20
5	MC	Deburr & Tumble as per Dwg D3411	pmr	09/07/01	20
6	QC5	Inspect work to Step 5	pmr	09/07/01	20
7	ST	Identify and Stock			
8	AC	Cost / part:			
9	DC	Close W/O ✓ Inspect Level 21 N/A			

Rev	Date	Change	Revised By	Approved
A	05.10.19	New issue	KJ/EC	



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3411	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE WASHER, DELRIN	SCALE NTS
A	05.03.16	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



1) SPECIFICATION: **D3411-X WASHER**

DASH No.

RELEASED
05.04.06 *[Signature]*

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH NO.	BOLT SIZE	A (in)	B (in)	T (in) ±0.006	NON-METALLIC REPLACEMENT FOR:
-3	#10	0.203	0.875	0.063	AN970-3
-4	1/4	0.265	1.125	0.063	AN970-4
-5	5/16	0.328	1.375	0.063	AN970-5
-6	3/8	0.390	1.625	0.063	AN970-6
-7	7/16	0.453	1.812	0.109	AN970-7
-8	1/2	0.515	2.000	0.109	AN970-8

also 00263

- 2) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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